Quality Control

Quality Control

QC8- Inspect parts - second check

Memo

120

Work Order ID 71881 Page 1 Wednesday, July 13, 2011 11:08:48 AM Item ID: D3492-7 Accept Setup Start **Revision ID:** Stop Item Name: Plug **Start Date:** 7/14/2011 **Start Qty: 20.00 Cust Item ID:** Required Date: 7/28/2011 Req'd Qty: 20.00 **Customer:** Reference: Run Start Date: 11-07/3 Process Plan: MF Approvals: **Tooling:** Date: Stop QC: ____ Date: _____ SPC (Y/N): Date: _ Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description Qty Number **Run Hours** Code Qty Stamp **Draw Nbr** Revision Nbr D3492 D 100 .0.00 Hardinge CNC LATHE SMALL Hardinge 0.00 Memo 1-Turn as per Folio FA644 & Dwg D3492 Dwg Rev:____ Hardinge CNC Lathe Small Folio Rev: 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo

0.00

117/27

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	Johna								
W/O:									
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	• <u></u>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Resolution:		Dispositio	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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Work Order ID 71881

Wednesday, July 13, 2011 11:08:48 AM



Page 2

Item ID:

D3492-7

· Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Plug

7/14/2011 **Start Oty: 20.00**

Required Date: 7/28/2011

Reg'd Otv: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC: Date:

Process Plan: _____ Date: Tooling:

Date:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Stop

Reject



Number Stamp

Insp.

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Description

Operation

Small Fab

1-Deburr necessary

2-Tumble

Memo

Memo

Set Up/ **Run Hours**

SPC (Y/N):

0.00

0.00

11/27

Accept

Qty

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

20 BK 11-7-27

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W/O:			WO	RK ORDER CHANG	BES				·			
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		PAR #:	Fault Categ	ory:	NCI	R: Yes	No DQ	Qty Chief Eng / Prod Mgr QC Inspector DQA: Date: Date: rification Approval Approval				
Res		esolution:	Disposition	:	QA	NC C	losed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCI	R)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng						Approval QC Inspector		
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Work Order ID 71881

Wednesday, July 13, 2011 11:08:48 AM



Page 3

Item ID:

D3492-7

Accept

Setup Start

Revision ID:

Start Date:

Item Name: Plug

7/14/2011

Start Oty: 20.00

Rea'd Otv: 20.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: Date:

Tooling:

Set Up/

Run Hours

Date:

Tool # Plan

Code

Start Run

Stop



Required Date: 7/28/2011

Date: _____

SPC (Y/N):

Date:

Stop

Insp.

Sequence ID/

Work Center ID

160

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

11118439

Memo

(Flat End Only)

9:00pm START TIME: OVEN TEMPERATURE: 3204 G(300

FINISH TIME:

0.00

0.00

Accept

Otv

Reject

Otv

Stamp Number

Reject

170

QC

Quality Control

QC3-Inspect Part Finish

180

Packaging

Identify as per dwg & Stock Location: FP-1

Memo

0.00

20

Memo

0.00

Packaging

/ 10	·oopaoc									•
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ	A :	_ Date: _	
Resolution:		esolution:	Disposition	າ:	_ QA: N/0	Clos	ed:		Date: _	
NCR:	NCR:			ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC Section A			gn &	Verific Section		Approval Chief Eng	Approval QC Inspector	
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Work Order ID 71881

Wednesday, July 13, 2011 11:08:48 AM



Page 4

Item ID:

D3492-7

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name: Plug

Required Date: 7/28/2011

7/14/2011

Start Oty: 20.00

Req'd Oty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Memo

Operation

Description

Date:

Date:

Tooling:

Date:

Tool ID

Tool # Plan

Date:

Code

Start

Stop



Sequence ID/

Work Center ID

190

OC

QC21- Final Inspection - Work Order Release

Run Hours

0.00

SPC (Y/N):

Set Up/

0.00

Accept

Qty

Run

Reject Otv

Reject Number

Insp. Stamp

Quality Control

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W/O:			N	ORK ORDER CHAN	GES		,			
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NCR:		\	WORK OR	DER NON-CONFORM	MANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Action Description	ection B n	Sign & Verification			Approval Chief Eng	Approval QC Inspector
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Picklist Print

Wednesday, July 13, 2011 11:08:45 AM

Work Order ID: 71881

Parent Item:

D3492-7

Parent Item Name: Plug



Start Date: 7/14/2011

Required Date: 7/28/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	71.0220	0.06	1.263158			
										Le	11/	1/2	J

6061-T6 Round Bar .500"

Loc Qty Location Loc Code MAT012 71.022 114488 4.322 66.7

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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		esolution:							
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector

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D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X			ĺ				D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1	-	 				D3492-1	PLUG
	 ' -	1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-7	
							D3492-9	PLUG
					1			PLUG
	├ ──				<u> </u>	1	D3492-13	PLUG
	1	1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1			i			NAS1611-013	O-RING
					1		NAS1611-015	O-RING
	1			1			NAS1611-016	O-RING

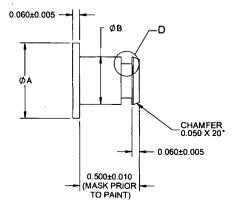
NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

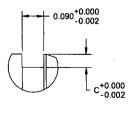
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	DART AERO	SPACE LTD
DRAWN	AJS	HAWKESBURY, O	NTARIO, CANADA
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JER	D3492	SHEET 1 OF 2
APPROVED	VAK	TITLE	SCALE
DE APPR.	7	PLUG	2:1
DATE 11.0	05.24	COPYRIGHT © 2007 BY THIS COCUMENT IS PROVIDE AND COMPRESHING AND NOT TO BE USED FOR ANY PURPOSE OR COPIED OR	

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W/O:			WC	ORK ORDER CHANGE	S				
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DATE	STEP	Description of NC		Corrective Action Section		Verification Approx			QC Inspector Approval
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POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7.	.0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. D D3492 MFG. APPR. SHEET 2 OF 2 TITLE APPROVED SCALE **PLUG** DE APPR. 4:1 COPYRIGHT © 2007 BY DART AEROSPACE LTD

PAS DOCUMENT IS PRIVATE, AND CONFEDENTIA, AND IS SUPPLIED ON THE EXPRESS CONCINTON THAT IT NOT TO BE USED FOR MAY REPORCE OF CONCENTRATION FOR A TRANSPORT AS TO ANY OTHER REPORTS HAND THE ARROWS THAT ARROWS ALL THE PERMISSION PROBLEMS AND TRANSPORT AS TO ANY OTHER PERMISSION PROBLEMS AND THE PERMISSION PR DATE 11.05.24

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 61 IDENTIFICATION: NIA

6) IDENTIFICATION: N/A 7) WEIGHT: N/A

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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	Part No: PAR #:		Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
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DART AEROSPACE LTD	Work Order:	71881
Description: Plug	Part Number:	D3492-7
Inspection Dwg: D3492 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.270	+0.006/-0.001	-241			Z X	
Ø0.500	+0.006/-0.001	.499				
0.500	+/-0.010	,500				
0.045	+0.000/-0.002	044				
0.060	+/-0.005	-06/				
0.060	+/-0.005	-060				
0.090	+0.000/-0.002	-089				
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				41. 41.		
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Measured by:	The	/ 1	Audited by:	H.A] [Preliminary Approvál:	
Date:	417	27	Date:	11/07/27		Date:	

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue P/O D3492-047	KJ/JLM.	11
В	11.06.21	Dwg Rev updated	KJ OC	
			171 0	7

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #		PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No DO)A:	Date: _	
Resolution:			Disposit	QA: N/C Closed:			Date:		
NCR:			WORK OR	DER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC Section A	Corrective Action Se		ion B		ication	Approval Chief Eng	Approval QC Inspector
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